DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 70.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-005092
Date Inspected: 15-Dec-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Japan Steel Works

OSM Arrival Time: 830
OSM Departure Time: 1800
Location: Muroran, Japan

CWI Name: Chung Kuan

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Tower Jacking and Deviation Saddles

Summary of Items Observed:

Caltrans Quality Assurance Inspector (QAI) representative Mr. Wai Pau traveled to Japan Steel Works (JSW) Muroran plant to observe two welders perform Flux Cored Arc Welding (FCAW) processes on the two ribs 9-10 and 9-11 of T1-3 tower saddle steel structure. The two weld numbers 9Y-10V-3-2 and 9Y-11V-3-3. The material used was reported by CWI Mr. Chung Kuan as ASTM 709-Gr345 plate having a thickness measurement of 120mm. The weld joint design used butt joint, double-V groove partial joint penetration groove weld (PJP). The filler metal and shield gas used for FCAW welding is Hoballoy wire TM-95K2, 1.6 diameter with 100% C02 made by Hobart Brothers, USA. The parameters used for FCAW welding of assemblies were conducted in accordance with Caltrans approved WPS #SJ-3012-3. The FCAW welding process and parameters have been monitored and recorded by CWI inspectors Mr. Chung Kuan. Based on Caltrans QA observation, the FCAW welding operation appeared to be in general compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Summary of Conversations:

The CWI Mr. Chung Kuan reported that FCAW welding on two ribs will be stopped when the weld is 70% complete, the tower sddle will turn 180 degree for other side welding.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510)385-5910, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer